

What is claimed is:

1. A laser apparatus comprising:
  - a block;
  - a plurality of laser diodes respectively having light-emission points and being fixed to said block so that the light-emission points are aligned along a direction; and
  - a collimator-lens array integrally formed to contain a plurality of collimator lenses which are arranged along a direction and respectively collimate laser beams emitted from said plurality of laser diodes;

wherein said block has a lens-setting surface which is flat, perpendicular to optical axes of said plurality of laser diodes, and located on a forward side of said plurality of laser diodes at a predetermined distance from said light-emission points, and said collimator-lens array is fixed to said block so that an end surface of the collimator-lens array is in contact with said lens-setting surface.
2. A laser apparatus according to claim 1, wherein said lens-setting surface has a flatness not greater than 0.5 micrometers.
3. A laser apparatus according to claim 1, wherein said block has a laser fixation surface on which said plurality of laser diodes are fixed, and the laser fixation surface has a flatness not greater than 0.5 micrometers.
- 25 4. A laser apparatus according to claim 1, wherein said plurality of laser diodes are realized by a multicavity

laser-diode chip having a plurality of light-emission points.

5. A laser apparatus according to claim 1, wherein said plurality of laser diodes are realized by a plurality of multicavity laser-diode chips each having a plurality of  
5 light-emission points.

6. A laser apparatus according to claim 1, wherein said plurality of laser diodes are realized by a plurality of single-cavity laser-diode chips each having a single light-emission point.

10 7. A laser apparatus according to claim 1, wherein each of said plurality of laser diodes is realized by a nitride-based compound laser-diode chip,

      said block is a heat-dissipation block made of copper or copper alloy,

15           said laser apparatus further comprising a plurality of submounts which are made of a material having a thermal expansion coefficient of 3.5 to  $6.0 \times 10^{-6}/^{\circ}\text{C}$ , have a thickness of 200 to 400 micrometers, and are separately formed on said heat-dissipation block,

20           each of said plurality of laser diodes and said plurality of submounts has a bonding surface, and

      each of said plurality of laser diodes is junction-side-down mounted on one of said plurality of submounts in such a manner that the bonding surface of said  
25 each of the plurality of laser diodes is bonded to the bonding surface of said one of the plurality of submounts through a

metalization layer and an Au-Sn eutectic solder layer each of which is divided into a plurality of areas.

8. A laser apparatus according to claim 7, wherein each of said plurality of laser diodes contains a light emission region, and said metalization layer and said Au-Sn eutectic solder layer are separated by a groove which is arranged immediately below the light emission region.

9. A laser apparatus according to claim 7, wherein said plurality of submounts are made of AlN.

10. A laser apparatus according to claim 7, wherein said plurality of submounts are bonded to the heat-dissipation block with Au-Sn eutectic solder.

11. A laser apparatus comprising:

15        a plurality of blocks stacked in a plurality of layers;

              a plurality of laser diodes respectively having light-emission points and being fixed to said plurality of blocks so that the light-emission points are aligned in said plurality of layers in each of which more than one of the 20 light-emission points are aligned along a predetermined direction; and

              a plurality of collimator-lens arrays arranged in correspondence with said plurality of layers, each of the plurality of collimator-lens arrays is integrally formed to 25 contain a plurality of collimator lenses which are arranged along said predetermined direction, and the plurality of

collimator lenses in the plurality of collimator-lens arrays respectively collimate laser beams emitted from said plurality of laser diodes;

wherein said plurality of blocks respectively have  
5 lens-setting surfaces, said lens-setting surfaces are flat, perpendicular to optical axes of said plurality of laser diodes, and located on a forward side of said plurality of laser diodes at a predetermined distance from said light-emission points, and said plurality of collimator-lens arrays are fixed to said  
10 plurality of blocks so that end surfaces of the plurality of collimator-lens arrays are respectively in contact with said lens-setting surfaces.

12. A method for producing a laser apparatus including a block, a plurality of laser diodes respectively having light-emission points and being fixed to said block so that the light-emission points are aligned along a direction, and a collimator-lens array integrally formed to contain a plurality of collimator lenses which are arranged along a direction and respectively collimate laser beams emitted from  
20 said plurality of laser diodes; said method comprising the steps of:

(a) forming in said block a reference surface which is flat, perpendicular to optical axes of said plurality of laser diodes, and located on a forward side of locations at  
25 which said plurality of laser diodes are fixed to the block;

(b) adjusting a position of each of said plurality

of laser diodes in a direction parallel to said optical axes based on information obtained by measurement of a focal length of one of the plurality of collimator lenses corresponding to said each of said plurality of laser diodes, and fixing said  
5 each of the plurality of laser diodes at the adjusted position; and

(c) adjusting positions of said plurality of collimator lenses along said reference surface, and fixing the plurality of collimator lenses at the adjusted positions.

10 13. A laser apparatus comprising:

a block;

a plurality of laser diodes respectively having light-emission points and being fixed to said block so that the light-emission points are aligned along a direction; and

15 a plurality of collimator lenses which are arranged along a direction and respectively collimate laser beams emitted from said plurality of laser diodes;

wherein said block has a reference surface which is flat, perpendicular to optical axes of said plurality of  
20 laser diodes, and located on a forward side of portions of said block to which said plurality of laser diodes are fixed,

each of the plurality of laser diodes is fixed to said block in such a manner that a position of said each of the plurality of laser diodes in a direction parallel to said optical axes is adjusted based on a focal length of one of the plurality of collimator lenses corresponding to said each of

the plurality of laser diodes, and

said plurality of collimator lenses are fixed to  
said reference surface in such a manner that positions of the  
plurality of collimator lenses are adjusted along said  
reference surface.

14. A laser apparatus according to claim 13, wherein  
said block is a heat-dissipation block, said plurality of laser  
diodes are junction-side-down mounted on a plurality of  
submounts, and said plurality of submounts are arranged on said  
block so that said light-emission points are aligned along a  
line.

15. A laser apparatus according to claim 14, wherein  
each of said plurality of laser diodes has a visible feature  
indicating a position of emission at a front end of said each  
of said plurality of laser diodes, and said plurality of laser  
diodes and said plurality of submounts are arranged so that  
said visible feature can be viewed from a submount side.

16. A fiber module comprising:

an optical fiber;

20 a support member for supporting an end portion of  
said optical fiber;

a light source; and

25 an optical system which makes light emitted from  
said light source enter said optical fiber from an end face  
of the optical fiber;

wherein said optical fiber is bonded to said

support member with a thin layer of an ultraviolet-light-curing type adhesive.

17. A laser apparatus according to claim 16, wherein said support member is optically transparent.

5       18. A laser apparatus according to claim 16, wherein said optical fiber is a multimode optical fiber, said light source is realized by a plurality of laser diodes, and said optical system is an optical condensing system which collects laser beams emitted from the light source, and makes the  
10      collected laser beams enter said optical fiber.

15       19. A laser apparatus according to claim 18, wherein said plurality of laser diodes are arranged so that light-emission points of the plurality of laser diodes are aligned along a line parallel to active layers of the plurality of laser diodes, said optical condensing system comprises a plurality of collimator lenses and a condensing lens, said plurality of collimator lenses are respectively provided in correspondence with said plurality of laser diodes, collimate laser beams emitted from the plurality of laser diodes, and each have a first aperture diameter in a direction parallel to said line and a second aperture diameter in a direction perpendicular to said line and greater than the first aperture diameter, and said condensing lens collects the laser beams collimated by the plurality of collimator lenses, and makes  
20      the collimated laser beams converge on said end face of the optical fiber.  
25

20. A laser apparatus according to claim 19, wherein  
said plurality of collimator lenses are integrally formed into  
a lens array.

5       21. A laser apparatus according to claim 18, wherein  
said plurality of laser diodes are mounted on a plurality of  
blocks which are joined.

10      22. A laser apparatus according to claim 18, wherein  
said multimode optical fiber has a core diameter not greater  
than 50 micrometers and a numerical aperture not greater than  
0.3.

15      23. A laser apparatus according to claim 18, wherein  
said multimode optical fiber has a core diameter and a numerical  
aperture, and the core diameter multiplied by the numerical  
aperture is not greater than 7.5 micrometers.

20      24. A laser apparatus according to claim 18, wherein  
said plurality of laser diodes are fixed so that the plurality  
of laser diodes are two-dimensionally arranged when viewed from  
a laser-receiving side.

25      25. A fiber module comprising a plurality of laser units  
each of which includes:

          a multimode optical fiber;  
          a support member for supporting an end portion of  
said multimode optical fiber;

25      a plurality of laser diodes; and  
          an optical condensing system which collects laser  
beams emitted from the light source, and makes the collected

laser beams enter said multimode optical fiber from an end face  
of the optical fiber;

wherein said multimode optical fiber is bonded to  
said support member with a thin layer of an  
5 ultraviolet-light-curing type adhesive.

26. A fiber module according to claim 25, wherein said  
multimode optical fiber in the plurality of laser units is  
arranged to constitute a one-dimensional array or a bundle at  
least at a light-emitting end of the multimode optical fiber.